

Date: Tuesday, 03/03/2009 4:16:55 PM
 User: Julie Dawson

Process Sheet

Customer : CC-EUR01 Eurocopter France	Drawing Name : LONG STEP ASSEMBLY HIGH SKID RH
Job Number : 46279	
Estimate Number : 13561	
P.O. Number :	Part Number : D350591312
This Issue : 03/03/2009 S.O. No. :	Drawing Number : D3272 REVB-EUROCOPTR
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 46278	Material :
Written By :	Due Date : 10/04/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JD 09.03.04</u>	
Comment : Est Rev:A 04.03.22 New issue KJ/RF Est Rev:B 07-06-09 Added D3572-1 JLM Est. returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JD 09/04/08

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

5 09/04/08

2.0	D32721	Step
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

STEP

BATCH: B 44570

DK 09.03.31 10

3.0	D30671	End Plate
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate B44330

DK 09.03.31 10

4.0	D32191	Plate
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3219-1 Support B44397

DK 09.03.31 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 46279

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M110130
M110431

3-Grind End Plate flush

SAO 09-03-31 10

SAO 09-03-31 10

SAO 09-03-31 10

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SAO 09-04-01 10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAO 09-04-01 10

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAO 09-04-01 10

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-H 09/04/02

✓ 10.0

D3065041

Step Leg Assembly Hi



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3065-041 Step Leg Assy

B45395

SAO 09-04-02

✓ 11.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3066-1

Spacer

B45396

SAO 09-04-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CC-EUR01 Eurocopter France

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 46279

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 12.0 MS20600AD4W4 Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 MS20600AD4W4 Rivet *M110731*

SAD 09-04-02

13.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

SAD 09-04-02 (10)

14.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 09-04-02 (10 RH)

15.0 D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate *346334*

SAD 09-04-02 10

16.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *M110130*

4-Grind End Plate flush

5-Install last rivet.

SAD 09-04-02 10

SAD 09-04-02 10

SAD 09-04-02 10

SAD 09-04-03 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 46279

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 09/04/03 (10)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/03 10RH

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

BR 09-04-3 (10RH)

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 M110939

START TIME: 10:15

OVEN TEMPERATURE: 320°

FINISH TIME: 10:45

BR 09-04-7 (10RH)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

M111013

FL 09/04/07 (10)

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

S 09/04/07 (10RH)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0

D22303

Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2230-3 Mounting Lug

40915

9/4/8

54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/03/2009 4:16:56 PM
User: Julie Dawson

Process Sheet

Customer: CC-EUR01 Eurocopter France

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 46279

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

D2618

Bushing

Handwritten: S (H) with checkmarks



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Handwritten: S (H)

Qty Part Number Description Batch

2 D2618

Bushing

Handwritten: 1545392

Handwritten: SP

26.0

D2856400

Abrasion Strip

Handwritten: S (H)

Handwritten: checkmarks



Comment: Qty.: 0.6000 f(s)/Unit Total: 6.0000 f(s)

Abrasion Strip

2 x D2856-400-720

Handwritten: 42437

Handwritten: 8809/04/08

27.0

D32351

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Handwritten: S (H)

Qty Part Number Description Batch

2 D3235-1

Mounting Lug

Handwritten: 44702

Handwritten: 44702

Handwritten: SP

28.0

D3278041

Support Assembly

Handwritten: S (H) with checkmarks



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Handwritten: S (H)

Qty Part Number Description Batch

1 D3278-041

Support Assembly

Handwritten: 45401

Handwritten: SP

29.0

AN335A

Bolt

Handwritten: S (H) with checkmarks



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Handwritten: S (H)

Qty Part Number Description Batch

2 AN3-35A

Bolt

Handwritten: M110467

Handwritten: SP

30.0

AN413A

Bolt

Handwritten: S (H) with checkmarks



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Bolt

batch: M110552

Handwritten: 9/4/8

Handwritten: 100

Handwritten: SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CC-EUR01 Eurocopter France

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 46279

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN536A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-36A

Bolt

M110731

50

32.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10

Washer

M110523

50

33.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

M110363

50

34.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516

Washer

M110523

50

35.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3

Nut (or -3)

M110399

9/4/8

100

50

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 46279

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

1110282

37.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5

Nut (or -5)

1109840

9/14/14

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591312

Location:

Rev B 9/14/14

40.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-04-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET



GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

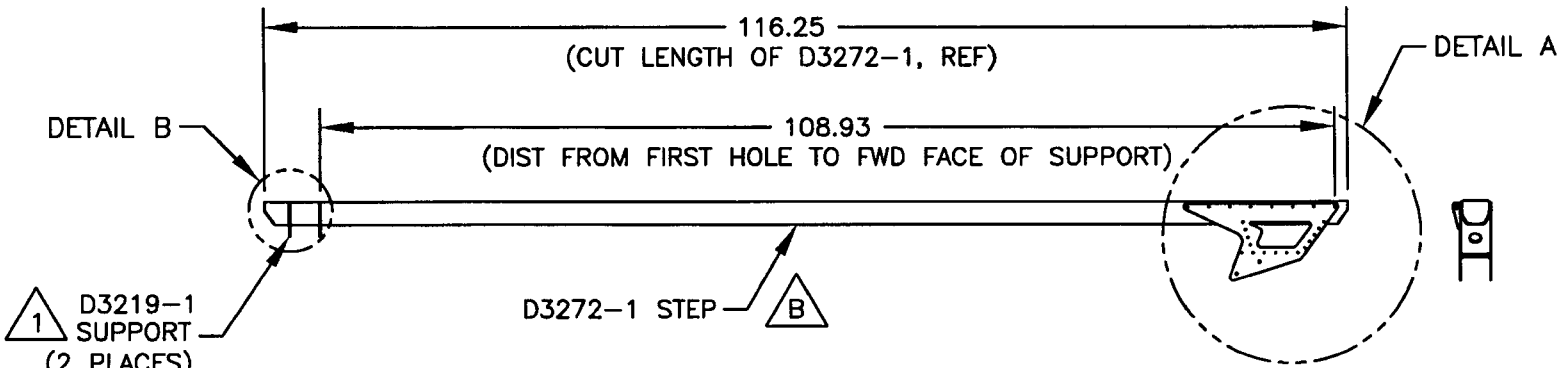
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WORK ORDER
NO. *46279*

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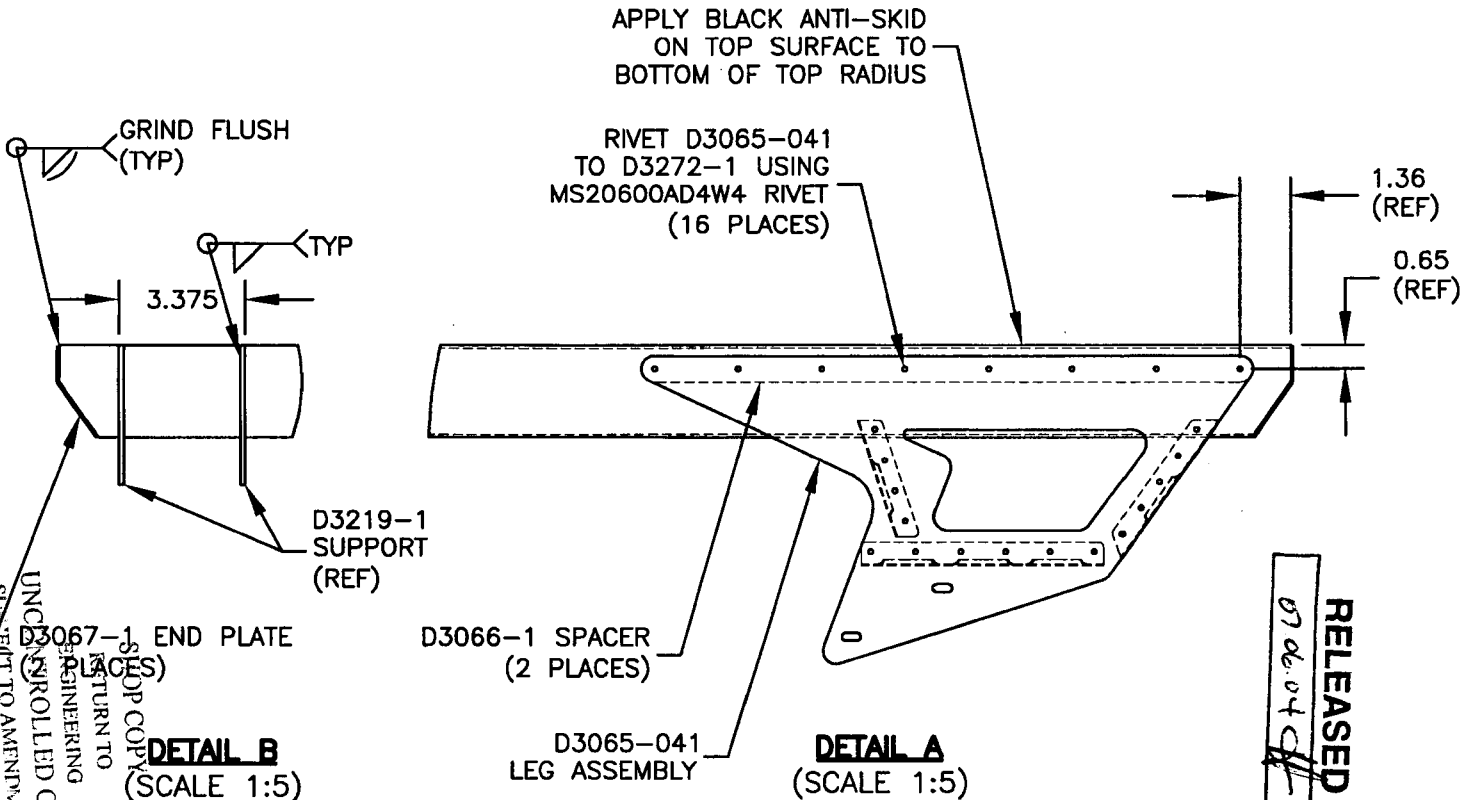
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DART

DESIGN	99	DRAWN BY	J.B.	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		REV. B
CHECKED	CE	APPROVED	[Signature]	DRAWING NO.	D3272	SHEET 2 OF 3
DATE	07.05.18			TITLE	STEP ASSEMBLY, HI LONG	
				SCALE	1:20	



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED
07 Dec 04

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NO. 1

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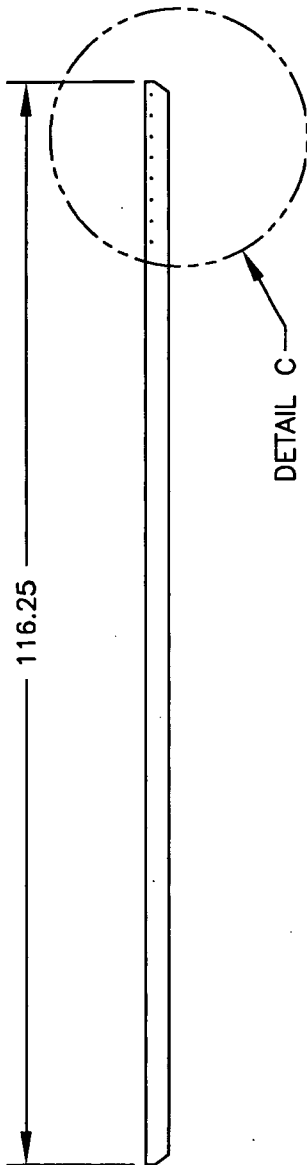
WORK ORDER
NO. 16221



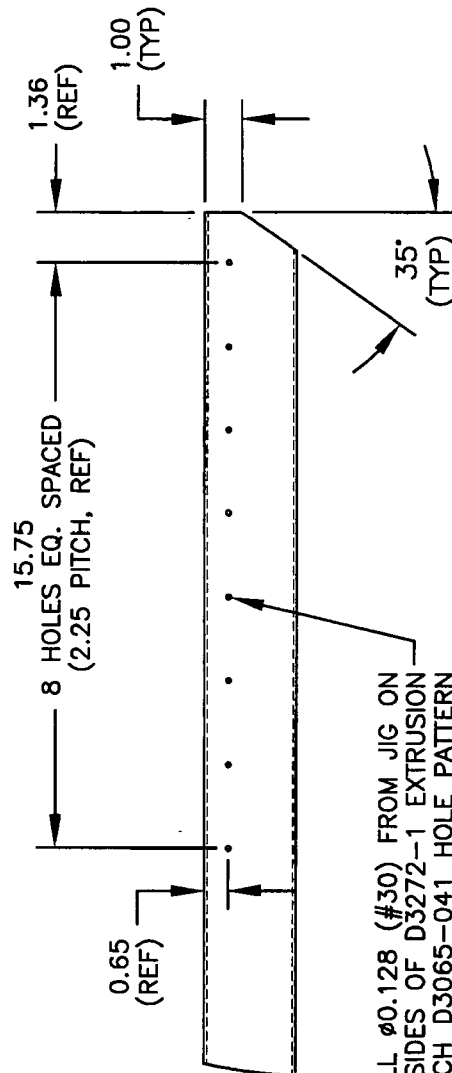
DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

07.06.04 *[Signature]*



B **D3272-1 STEP**
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46279

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